Work Orde Thursday, Septen														Page 1
Item ID: Revision ID:	D3286-3			A	ccept						Setup S	Start		
	Spacer										5	Stop		
Start Date: Required Date:	9/22/2011 9/29/2011	Start Qty: 80.00 Req'd Qty: 80.00					Cust Item I Customer:	D:						
Reference:				· .	.•								1 (8 8 111 8 1 8 8	
Approvals:	Process Pla	ın:	Date:_		Tooling:			ate:		F		Start Stop		
*	QC:		Date:_		SPC (Y/N):		Da	ate:				•		
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hou	ırs	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr												
D3286	Rev	Α			· · · · · · · · · · · · · · · · · · ·				· ·		,			
		Hardinge CNC LATHE	E SMALL		0.00				(83	Q			
Hardinge Hardinge CNC Lath	e Small	Memo Turn blank	cs as per Folio	FA434 and Dwg	0.00 D3 3 86						/		•	:
,	, ·		[per Dwg D32			11)5	V22							
110	**	QC2- Inspect parts off	machine FAI/	FAIB	0.00					ダて	1	5		
·QC	•	Memo		\	0.00									-
Quality Control				2	11	1912	2							
120		QC8- Inspect parts - se	cond check		0.00		, .							
		Memo			0.00	and,	u/04/2	.3		83		Ø		

Quality Control

DATE STEP PROCEDURE CHANGE By Date Qty Approach Chief Er Prod M Part No:	
Part No:	g/ Approvar
Resolution: Disposition: QA: N/C Closed: Date	<u>r </u>
Resolution: Disposition: QA: N/C Closed: Date	
Resolution: Disposition: QA: N/C Closed: Date	
Resolution: Disposition: QA: N/C Closed: Date	
Resolution: Disposition: QA: N/C Closed: Date	
Resolution: Disposition: QA: N/C Closed: Date	
):
):
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Appro	val Approval
STEP Section A Section A Section Chief Eng Section C Sec	ng QC Inspector

Work Order ID 74117



Page 2

Thursday, September 22, 2011 1:42:17 PM

Item ID:

Revision ID:

D3286-3

Accept



Setup Start



Stop

Item Name: **Start Date:**

Spacer 9/22/2011

Required Date: 9/29/2011

Start Qty: 80.00

Req'd Qty: 80.00

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Start

Stop



Reject

Qty

Reject

Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

0.00

STOCK IN SKIDTUBE CELL

0.00

Accept

Qty

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

- Marzi 12 me 11-09-23

Dart Aerospa	ce	Ltd
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W/O:			W	GES	S						
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							,		·		
Part No: PAR #: Fault Category: NCR: Yes No I											
Resolution: Disposition:									Date:		
NCR:		V	VORK ORI	DER NON-CONFORM	MANCE	(NCR)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector	
			Office Ling	One Ling	-	Date					
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Picklist Print

Thursday, September 22, 2011 1:42:15 PM

Work Order ID: 74117

Parent Item:

D3286-3

Parent Item Name: Spacer

Start Date: 9/22/2011

Required Date: 9/29/2011

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP A□04.07.14□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			110	f	247.1211	0.3417	28.77474	W	9/2	2

304 RD Tube .500 x .049W

Location	Loc Qty	Loc Code
MAT017	247.121058	
. 111814	2.23	
115010.	145.421058	
417598	99.47	

30 Pt

Dart Aerospace	Ltd
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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
				,									
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:								
Resolution:			Disposition	1:	_ QA: N/C Cld	QA: N/C Closed: Date: _							
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			\$ - P\$ - P\$				
DATE	STEP	Description of NC		on B		cation	Approval	Approval					
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	14117
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
		. 🗓	First Artic	cle	Prot	otype				
	awing ension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments		
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Measu	ured by:	12	Audited by:	and		Prototype Ap	proval:	N/A		
	Date:	118/22	Date:	11/09	4 3		Date:	N/A		
Rev	Date	Change					evised by			
Α	04.09.01	New Issue				K	J/JLM ح	FI (111/		

Dart Aerospace Ltd

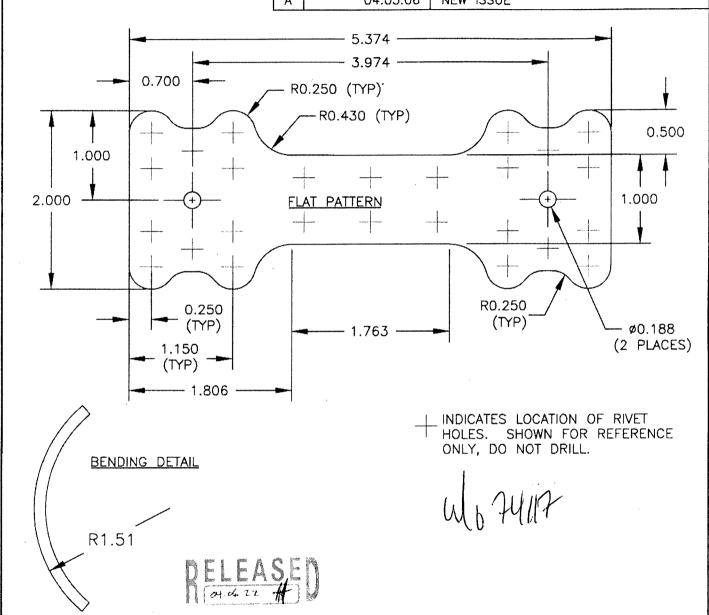
	Обрасс									
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Dart No.	<u> </u>	DAD #•	Foult Cate	AGON!	NCP: Voc	No DO	<u> </u>	Date		
rait NO			Fault Category:							
Resolution:				on:				Date: _ 		
NCR:			VORK ORD	ER NON-CONFORMA	NCE (NCF	R)			!	
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Section		Chief Eng	QC Inspector	
								,		

[→] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





DESIGN (P	DRAWN BY	DART	AEROSI PORT F	PACE IADLOCK, V		INC.
CHECKED,	APPROVED	DRAWING NO.				REV. A
#-	4	D3286	•		SHE	ET 1 OF 2
DATE		TITLE				SCALE
 04.05.06		GROUND	HANDLING	PARTS		1:1
Δ	04.05.06	NEW ISS	IF			



D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
- (REF DART SPEC, M304S11GA) 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Dart Aei	rospace	Lla							
W/O:			W	ORK ORDER CHANGE	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NCI	R)			TO STATE OF THE ST
		Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	Chief Eng	QC Inspector
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DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECKED,	APPROVED;	DRAWING NO.		REV. A
I ₩-	-11	D3286		SHEET 2 OF 2
DATE		TITLE		SCALE
04.05.06		GROUND I	HANDLING PARTS	1:1

— 4.000 ——	 -
	Ø0.500
4	

03286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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Dart Aerospace	Lto	3
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	1									
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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<i>;</i>										
Part No:		PAR #:	Fault Category:		NCR: Yes	ICR: Yes No DQA:		Date:		
	R	esolution:	Dispositi	on:	QA: N/C Closed:			Date: _		
NCR:		1	WORK OR	DER NON-CONFORMAN	NCE (NCF	R) —		,		
DATE	STEP	Description of NC	Corrective Action Section B				Verification	Approval	Approval	
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